

Work Order ID 67743

Wednesday, March 30, 2011 7:45:58 AM



Page 1

Item ID: D2052

Accept



Setup Start



Revision ID:

Item Name: Mounting Bracket

Stop



Start Date: 3/30/2011 Start Qty: 15.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 15.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: *11-03-30* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2052

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

5052.090

1-Cut as per Dwg D2052

Dwg Rev: *D*

Prog Rev: *D*

****grain direction along 3.878" ****

2-Deburr if necessary

B11-3-30

57

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8 u03/31

Quality Control

count
(27)

130

NC BRAKE

0.00



Brake NC

Memo

0.00

SB 116464

Brake NC

Form as per Dwg D2052 using CNC Brake

(27)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 u04/04

Quality Control

count
(22)

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Chemical Conversion Coat per QSI005 4.1 0.00

HandFinish

Memo

0.00

Hand Finishing

27 ϕ JH 11/01/06

160 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

Powdercoat

M115128.

Memo

0.00

Powder Coating

START TIME: 10:05
OVEN TEMPERATURE: 320°
FINISH TIME: 10:35

27 ϕ R 11-4-7.

170 QC3- Inspect Part Finish 0.00

QC

Memo

0.00

Quality Control

27 ϕ JH 11/04/07

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

SB 1164108

(27)

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/82

P/1204-8

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, March 30, 2011 7:46:06 AM

Page 1

Work Order ID: 67743



Parent Item: D2052



Parent Item Name: Mounting Bracket

Start Date: 3/30/2011

Required Date: 3/31/2011

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP C01.08.21 Added Finishing SM (Issue this IPP with part number D2053)
 IPP Rev:D now water jet 07-10-25 DD
 IPP Rev:E 08-05-14 chg to revD as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090 		Purchased	No			100	sf	25.0000	0.129	2.036842	3.5		
5052-H32 .090 Sheet											B11-3-30		

Location

Loc Qty

Loc Code

MAT22

25

3019

25

3019

69

W/O:		WORK ORDER CHANGES						
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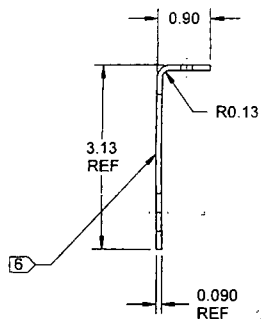
W/O:		WORK ORDER CHANGES						
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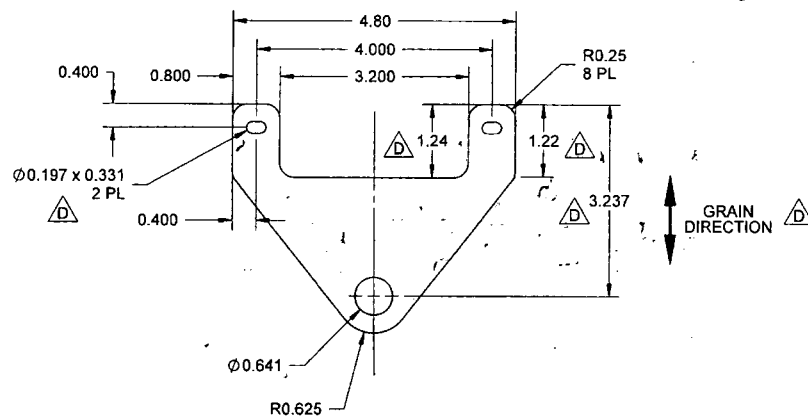
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D2052 BRACKET



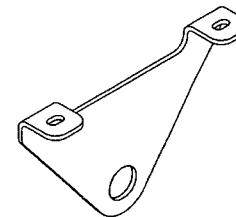
D2052F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR-T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2052" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.08 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67743

11-03-30



RELEASED
08-05-13

D	WIDEN SLOT (ZN B7-1); UPDATE FLAT PATTERN DIMENSIONS (ZN B5-1, B6-1); ADD 6061-T6 OPTION (ZN A5-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDEX (ZN A6-1); ADD IDENTIFICATION (ZN A4-1); ADD WEIGHT (ZN A8-1); ADD GRAIN DIRECTION (ZN B4-1); REASON: PRODUCT IMPROVEMENT (REF PAR 08-012)	PH	08.04.28
C	ADD FLAT PATTERN	RF	99.04.30
B	ADD SLOT TO FOOT	BW	97.02.21
A	NEW ISSUE	BW	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2052 REV. D SHEET 1 OF 1 TITLE BRACKET SCALE NTS COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PL		
CHECKED	PL		
MFG. APPR.	PL		
APPROVED	PL		
DE APPR.	PL		
DATE	08.04.28		

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